

Shp ~~Apr. 30~~ TODAY

Work Order ID 83885

April-26-12 3:00:33 PM

83885

Page 1

Item ID: D412-785-003-401

Revision ID:

Item Name: Pax Speaker Mount. Aft

Start Date: 4/26/12 Start Qty: 6.00

Required Date: 4/30/12 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D412-785-003-101

PC1

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: PC1

Prog Rev: PC1

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

PRELIMINARY ISSUE

B12-4-27

B12-4-25

5/2/12/30

46

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Page 2

Item ID: D412-785-003-401

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Start Date: 4/26/12 Start Qty: 6.00

Required Date: 4/30/12 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

130

Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

c'sink as per dwg

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

160

160

HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

⑥ 7/6 12.4.30

12/04/30

6x

0

⑥

Sched 30

Work Order ID 83885

April-26-12 3:00:33 PM

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Item ID: D412-785-003-401

Revision ID:

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Start Date: 4/26/12 Start Qty: 6.00

Required Date: 4/30/12 Req'd Qty: 6.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.00

Quality Control

6X

M/K
12/04/30

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

0.00

Packaging

G

12/4/30sf

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

POSITIVE RECALL
EFFECTIVE 12-04-26 AUTH W
RELEASED _____ DATE _____M/K
12-04-30

Picklist Print

April-26-12 3:00:32 PM

Work Order ID: 83885

Parent Item: D412-785-003-401

Start Date: 4/26/12

Required Date: 4/30/12

Parent Item Name: Pax Speaker Mount, Aft

Start Qty: 6.00

Required Qty: 6.00

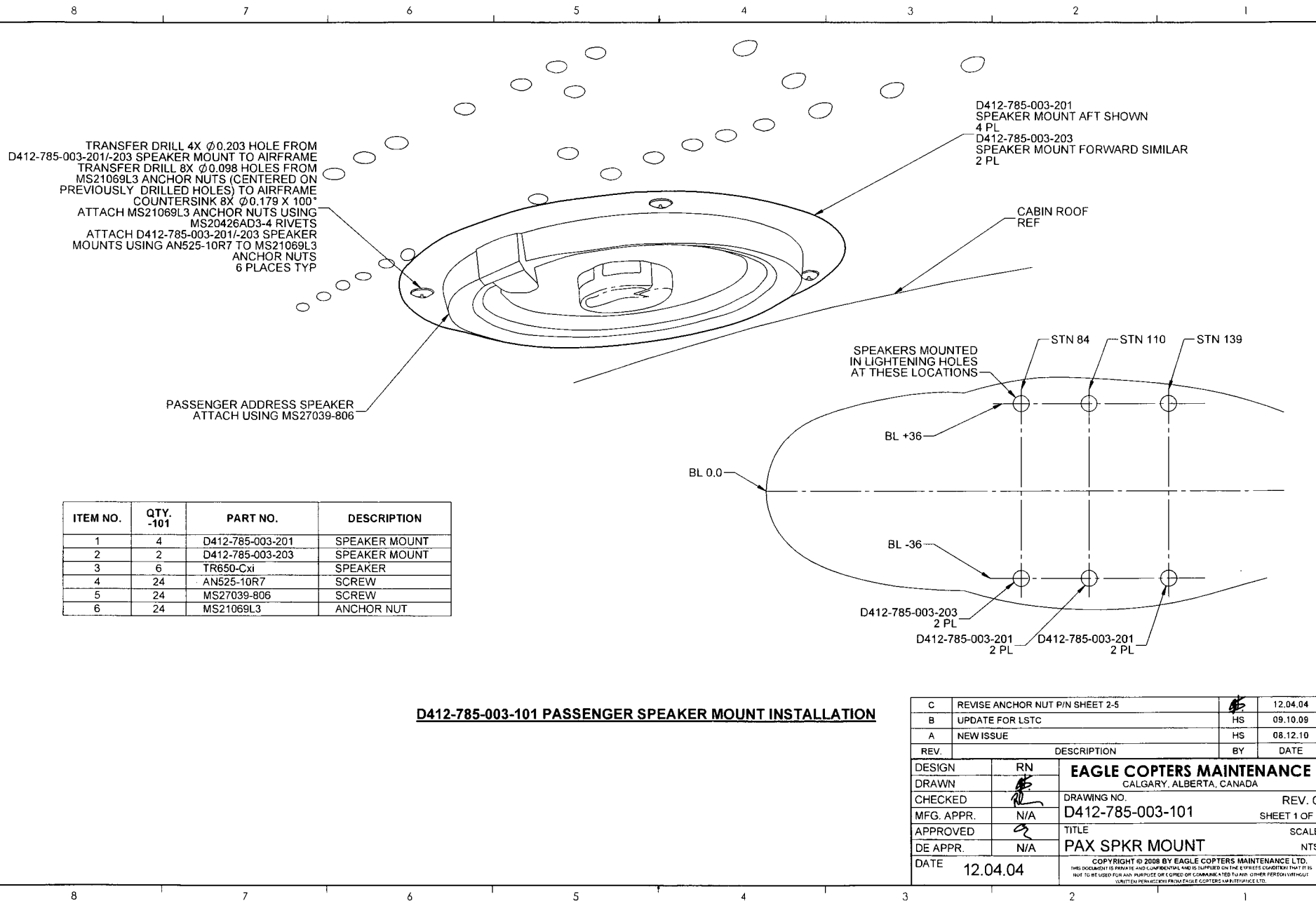
Comments: IPP REV:A NEW ISSUE 11-09-01 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No				sf	226.1912		3.1578947			

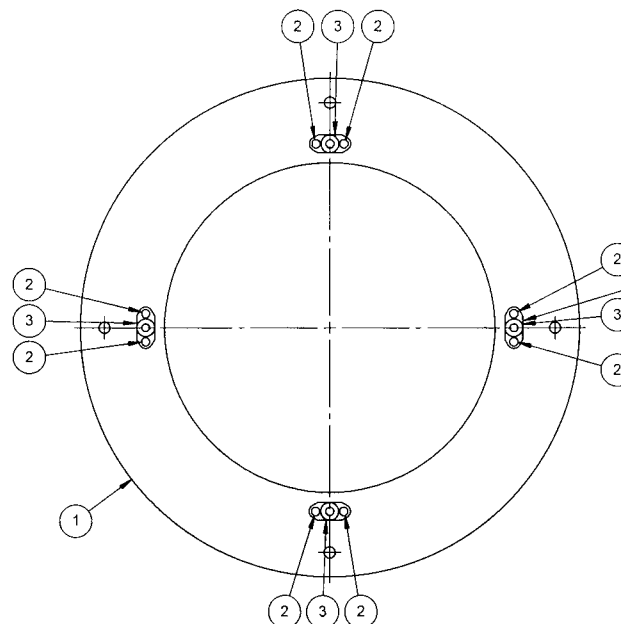
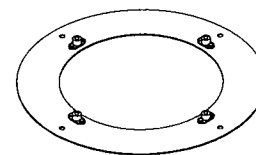
12-4-07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	226.1911626	
117684	21.318421	
120196	42.41	
120605	66.4627416	
121197	96	

120196



ITEM NO.	QTY. -201	PART NUMBER	DESCRIPTION
1	1	D412-785-003-401	PAX SPKR MOUNT, AFT
2	8	MS20426AD3(-4)	RIVET
3	4	MS21069L08	ANCHOR NUT



INSTALL MS21069L08 ANCHOR NUT
USING MS20426AD3 RIVETS
4 PL

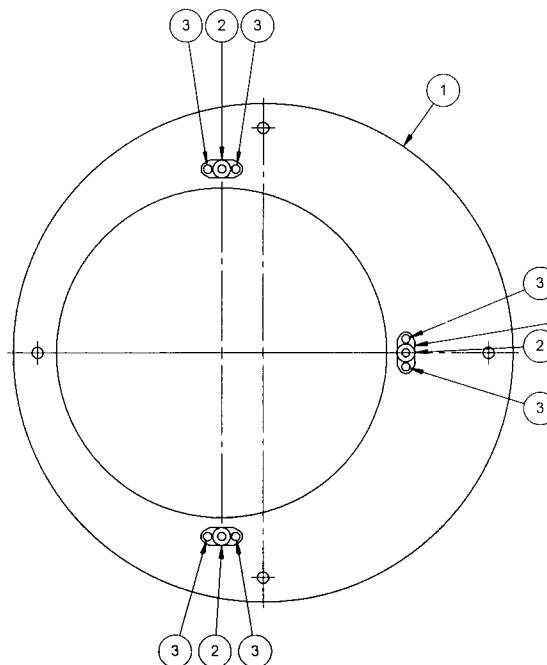
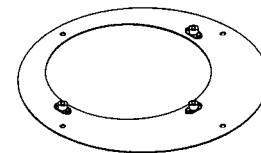
D412-785-003-201 PAX SPEAKER MOUNT AFT


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: IDENTIFY WITH DART P/N D412-785-003-201 USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: 0.12 lbs

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MFG. APPR.	N/A	D412-785-003-101	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
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ITEM NO.	QTY. -203	PART NUMBER	DESCRIPTION
1	1	D412-785-003-403	SPEAKER MOUNT, FWD
2	3	MS21069L08	ANCHOR NUT
3	6	MS20426AD3(-4)	RIVET






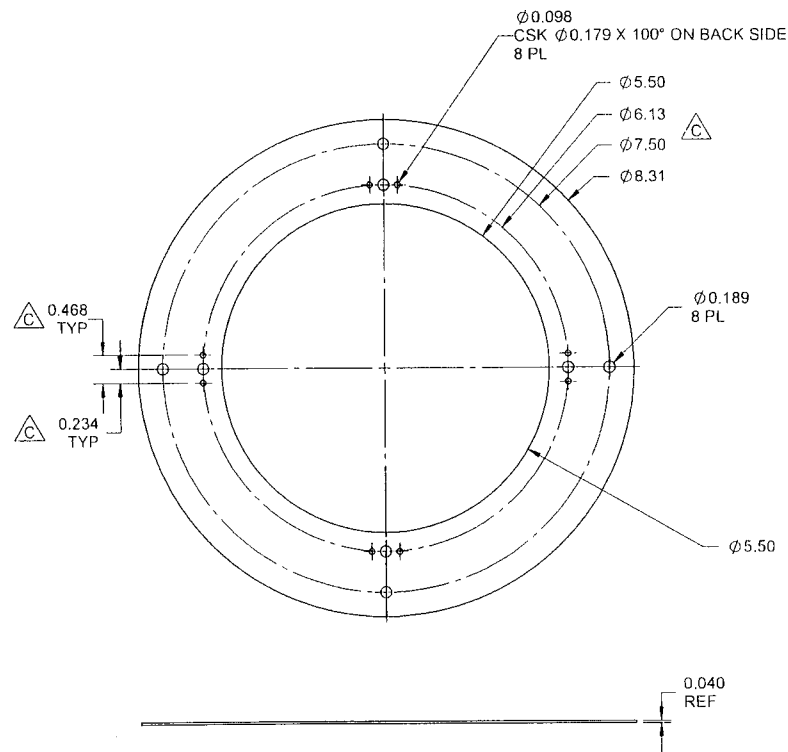
INSTALL MS21069L08 ANCHOR NUT 
USING MS20426AD3 RIVETS
3 PL

D412-785-003-203 PAX SPEAKER MOUNT FWD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: IDENTIFY WITH DART P/N "D412-785-003-203 USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: 0.05 lbs

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D412-785-003-401 PAX SPEAKER MOUNT AFT

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
 - 2) FINISH: ALODINE, PRIME AND PAINT PER BHT-412-MM
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 5) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.12 lbs

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
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